

# Work Order ID 54966

January 5, 2010 11:19:55 AM



Page 1

Item ID: D412-698-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Door Roller, RH

Start Date: 05/01/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 18/01/2010 Reqd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *RF*

Date: 10-1-05 Tooling:

Date:

Run Start

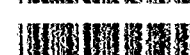


QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

HN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-012 CHG003

*ES 10/01/11*

*for BG 10/01/11*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*10-1-11 SP (2x)*

120

QC4- 100% inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*ES 10/01/11*

*(2x)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 54966

January 5, 2010 11:19:55 AM

Page 2

Item ID: D412-698-012

Accept

Setup Start

Revision ID:

Stop

Item Name: Cabin Door Roller, RH

Start Date: 05/01/2010 Start Qty: 2.00

Cust. ID:

Required Date: 18/01/2010 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Reu B

10-1-11

20 SP

Packaging

Identify and pack for shipping as per PPP D412-698-012  
Location: 62

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/12  
MF 10-1-12  
29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 5, 2010 11:19:59 AM

Page 1

Work Order ID: 54966

Parent Item: D412-698-012

Parent Item Name: Cabin Door Roller, RH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3121-141		Manufactured	No			110	Each	0.0000	6.0000			
-----------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--



Bracket Assembly

D3121-144		Manufactured	No			110	Each	4.0000	2.0000			
-----------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--



Bracket Assembly

BS4220 10-1-11 SF  
BS4758 2x  
10-1-11 SF

Warehouse  
Location

Main Warehouse

ST

52367

4

4

D3137-043		Manufactured	No			110	Each	17.0000	2.0000			
-----------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Bracket Assembly

10-1-11 SF

Warehouse  
Location

Main Warehouse

ST

42192

17

17

D3183-044		Manufactured	No			110	Each	2.0000	2.0000			
-----------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--



Bracket Assembly

10-1-11 (2x) SF

Warehouse  
Location

Main Warehouse

ST

54218

2

2

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 5, 2010 11:19:59 AM

Work Order ID: 54966

Parent Item: D412-698-012

Parent Item Name: Cabin Door Roller, RH


Comments:

Start Date: 05/01/2010


Required Date: 18/01/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3199-1  S 42 Bracket		Manufactured	No			110	Each	44.0000	18.0000		10-1-11 SP	

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	44	
47848	2	
53036	42	

D3202-1  S 42 Cover		Manufactured	No			110	Each	20.0000	2.0000		10-1-11 SP (2x)	
--	--	--------------	----	--	--	-----	------	---------	--------	--	-----------------	--

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	20	
50134	20	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS**

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

• COPYRIGHT © 2003 BY DART AEROSPACE LTD. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: E

Date: 08.05.01